Work Order ID 77767 *77767* Page 1 December-21-11 9:28:58 AM D350-748-101 *N900040100* Accept Item ID: Setup Start **Revision ID:** U/R Crosstube Installation, High Fwd **Item Name:** Start Qty: 1.00 21/12/2011 **Start Date: Cust Item ID: Required Date:** 13/01/2012 Req'd Qty: 1.00 **Customer:** Reference: Start Run Process Plan: $\mathcal{H} \cup \mathcal{J}$ Date: |V| | 2 | 2 | Tooling: Date: Approvals: Stop Date: SPC (Y/N): Date: Set Up/ Tool ID Sequence ID/ Operation Tool # Plan Accept Reject Reject Insp. Work Center ID Description Run Hour Code Qty Number Stamp **Qty Draw Nbr Revision Nbr** D350-748-141 F U/R 100 DOCUMENT CONTROL *100* Memo Photocopy bluefile & type labels per PPPD350-48 Document Control CHG002 0.00 110 BENDING MACHINE - CROSSTUBES *110* 12-1-18 CNC Bend 1 0.00 Bend tube as per Dwg D350-748-141 using CNC bender program D350F and CNC Delta 100 Bender Folio FT OC15- Crosstube Dimensional Check 0.00 120 *120* QC 0.00 Memo Quality Control

23

Dart	Aeros	pace	Ltd
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N/O:		20.00	W	ORK ORDER CHANG	ES	Anna Anna		1 A
DATE	STEP	PRO	CEDURE CH	ANGE	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approvál QC Inspector
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Part No	:	PAR #:	Fault Cate	egory:	_ NCR: Yes 1	No DQA:	Date: _	
•	Re	esolution:	Disposition	on:	_ QA: N/C Clo	sed:	Date: _	
NCR:		V	VORK ORD	ER NON-CONFORMA	NCE (NCR)			
DATE	STEP	Description of NC		Corrective Action Section		Verification	Approval	Approval
DAIL	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector
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Work Orden December-21-1				*777	767*							Page 2
Required Date:	21/12/2011	allation, High Fwd Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*	Accept	*N900 Cust Item I Customer:		100) * s	Setup	Start Stop	1 71 -	S1* S2*
Approvals:	Process Pla	n:	Date:	Tooling: SPC (Y/N):		ate:		F	Run	Start Stop	*N	R1* R2*
Sequence ID/ Work Center II 125 *175* HandFXtube Hand Finishing Cross		Memo ***Stress re Heat treat or Temp: 2 Start time:	osstube as per QSI010 4.3	Set Up/ Run Hours 0.00	Tool ID	Tool #	Plan Code	Accept Qty	Reje Qty		Reject Number	Insp. Stamp
127		Finish time:	8n30	0.00								

0.00

Memo

Quality Control

Dart Aerospace Ltd WORK ORDER CHANGES W/O: **Approval** Approval DATE **STEP** Qty **PROCEDURE CHANGE** By Date .Chief Eng / QC Inspector Prod Mgr Resolution: _____ Disposition: ____ QA: N/C Closed: ____ Date: ____ WORK ORDER NON-CONFORMANCE (NCR) NCR: **Corrective Action** Section B Verification **Description of NC Approval Approval STEP** DATE Initial **Action Description** Sign & Section A Section C Chief Eng QC Inspector Chief Eng Date Chief Eng

Work Orde December-21-11				*777	'67 *					Page 3
Item Name: Start Date: Required Date:	21/12/2011	allation, High Fwd Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*	Accept	*N900 Cust Item I Customer:		n *	Setup Star Stop	14.7	11* 12*
Approvals:	Process Pla	n:	Date:	Tooling: SPC (Y/N):		nte:		Run Star Stop	"IVH	?1* ?2*
Sequence ID/ Work Center II 130 *120* Crosstubes Crosstubes)	Set-up dri	as per Dwg D350-748 Il table as per QSI 010	Set Up/ Run Hours 0.00 0.00 -141 Using DT8876 A,B &C	Tool ID Drill Jigs,	Tool # Plan Code	Accept Qty	Reject Qty	•	nsp. Stamp
		4-Remove al	art # and Batch # as pe I marks from tube with ght coat of LPS3 on the Batch: M	in limits of D350-748-141	400	-1-24 1/25				

140

QC5- Inspect part completeness to step on W/O

0.00

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Memo

0.00

Quality Control

CHECK 10 DEG HOLES WITH DT8876E (EUROCOPTER CLAMP)

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W/O:			V	VORK ORDER CHANG	ES				
DATE	STEP	PRO	CEDURE CH	IANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Ca	•	NCR: Yes	No DQ	 A:	Date:	<u> </u>
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DATE	STEP	Description of NC			ion B	Verifi	cation	Approval	Approval
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Work Order ID 77767 December-21-11 9:28:58 AM			*77767*								Page 4	
Item ID: Revision ID: Item Name:	D350-748-1 U/R Crosstube Ins	01 tallation, High Fwd		Accept	*N900	040	100)*	Setup	Start Stop	*N:	S1*
Start Date: Required Date Reference:	21/12/2011 e: 13/01/2012	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item :	ID:					i Vi	.7/
Approvals:	Process Pla	an:	Date:	Tooling:	D	ate:		j	Run	Start	*N	R1*
	QC:		Date:	SPC (Y/N):		ate:				Stop	*N	R2*
Sequence ID/ Work Center	ID	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Rej Qty		Reject Number	Insp. Stamp
150		Outsource process-Cadpl	ate per QSI017 4.1.9.1	0.00				-	_			-
150 Outsource process	- Cad plate	Magnetic Pa Cadium Plat Embrittle rel Possibe Sup	at 375° for 5 hours rticle Inspect per ASTM e per AMS-QQ-P-416B, ief at 375° for 8 hours, C plier: Southwest United I ficate of Conformity is a	Class 1, Type 2 Chromate Treat ndustries				<u>C</u>	P 1.	12/0	125	Plot
*160 *160*		Receive & Inspect for Da	mage & Mat'l Certs	0.00								
Packaging Packaging		Memo Ensure certif	icate of conformity is att	0.00 ached								
170 *17 0*		QC5- Inspect part comple	eteness to step on W/O	0.00	POSITIVI EFFECTIVE			ı P				
QC Quality Control		Мето		0.00	RELEASED							

CHECK TWIST AFTER CAD-PLATER

Dart Aeros	pace Ltd
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W/O:		77767						
DATE STEP			PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No: <u>D3.50-@48-46.1</u>	PAR #:	Fault Category: American Crosstuly	NCR: (Yes) No	DOAL SUV	Date: <u>/7/03/</u>	16
		7- 7- 7- 7- 7- 7- 7- 7- 7- 7- 7- 7- 7- 7			47	1.00
Resolution: _	SURD	Disposition: Suran	QA: N/C Closed:	CY_	Date: 12 3	110

NCR:	`	WORK ORDER NON-CONFORMANCE (NCR)									
		Description of NC		Corrective Action Section B		Verification	Approval	Approval			
DATE	STEP	Section A	Initial Action Description Chief Eng		Sign & Date	Section C	Chief Eng	QC Inspector			
<i>હ</i> ીડી12	120	ture bole/cracles at cass Platting R.C. Prouss	12/03/12 05/12	no Replace	MO 12/3/13	12313	12/03/12	5 17 13/12			
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Work Order ID 77767 *77767* Page 5 December-21-11 9:28:58 AM Item ID: D350-748-101 Accept *N900040100* Setup Start Revision ID: U/R Item Name: Crosstube Installation, High Fwd **Start Date:** 21/12/2011 Start Qty: 1.00 **Cust Item ID: Req'd Qty:** 1.00 **Required Date:** 13/01/2012 **Customer:** Reference: Run Start Process Plan: _____ Date: ____ **Tooling:** Approvals: Date: Stop Date:_____ SPC (Y/N): Date: Sequence ID/ Operation Set Up/ **Tool ID** Tool # Plan Accept Reject Reject Insp. **Work Center ID** Description **Run Hours** Code Qty **Qty** Number Stamp 180 0.00 SprayPaint *120* SprayPaint 0.00 Memo **Spray Painting** 1-Prime inside crosstube as per OSI 005 4.2 2-Prime Outside of Tube as per Dart QSI 005 4.2 190 QC14- Inspect Spray Paint 0.00 *190* QC 0.00 Memo Quality Control Then, Wrap in plastic bag to protect from scratches

200

Crosstubes

Crosstubes

Memo

0.00

0.00

Crosstubes

1-Install Ground wire Insert then insert screw and washer

2-Install Abraision strips as per Dwg D350-748-141 & QSI 035.

3-Install supports Using Dt8876 as per Dwg D350-748-141, Torque to 60-80 IN-

LBS

W/O:			WORK ORDER CHANGES									
DATE	STEP	PR	PROCEDURE CHANGE			Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
Part No	•	PAR #:	Fault Cate	egory:	NCR: Ye	s No DQ	A:	_ Date: _				
Resolution:		olution:	Disposition	on:	QA: N/C	Closed:		Date: _				
NCR:			WORK ORD	ER NON-CONFORM	ANCE (NC	R)						
DATE	STEP	STEP Description of NC Section A		Corrective Action Sec Action Description Chief Eng	tion B Sigr Date	Verification Section C		Approval Chief Eng	Approval QC Inspector			
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. Work Order ID 77767 *77767* Page 6 December-21-11 9:28:58 AM D350-748-101 Accept Item ID: *N900040100* Setup Start **Revision ID:** U/R Crosstube Installation, High Fwd Item Name: *1* **Start Date:** 21/12/2011 Start Qty: 1.00 **Cust Item ID: Req'd Qty:** 1.00 **Required Date:** 13/01/2012 **Customer:** Reference: Run Start Process Plan: Date: Tooling: Approvals: Date: Stop _____ Date: ____ SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Accept Reject Reject Insp. **Work Center ID** Description **Run Hours** Code **Qty Qty** Number Stamp 210 QC5- Inspect part completeness to step on W/O 0.00 *210* QC 0.00 Memo Quality Control 220 Pick Kit 0.00 *220* Packaging 0.00 Memo Packaging 230 QC4-100% Inspect kits for completeness 0.00 QC 0.00 Memo

Quality Control

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W/O:			W	ORK ORDER CHANG	ES			<u> </u>	· · · · · ·
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DATE	STEP	Description of NC		Corrective Action Section		Verific	ation	Approval	Approval
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Work Order ID 77767 *77767* Page 7 December-21-11 9:28:58 AM Item ID: D350-748-101 Accept *N900040100* Setup Start U/R **Revision ID:** Crosstube Installation, High Fwd Item Name: *1* **Start Date:** 21/12/2011 Start Qty: 1.00 **Cust Item ID:** Req'd Qty: 1.00 **Required Date:** 13/01/2012 **Customer:** Reference: Run Process Plan: _____ Date:____ Tooling: **Approvals:** Date: Stop QC: ____ Date: SPC (Y/N): Date: Sequence ID/ Operation **Tool ID** Tool # Plan Set Up/ Accept Reject Reject Insp. **Work Center ID** Description Code **Run Hours** Qty Qty Number Stamp 240 0.00 Packaging *240* Packaging 0.00 Memo Packaging Identify and pack for shipping as per PPP D350-748-101 Location: PPP Rev: 250 QC21- Final Inspection - Work Order Release 0.00 *250*

0.00

Memo

Quality Control

\$12-03-13

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	Re	esolution:	Disposition	n:	QA: N/C CI	osed:		Date: _	
NCR:			WORK ORD	ER NON-CONFORMA	NCE (NCF	R)			
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December-21-11 9:29:02 AM

Work Order ID: 77767

77767

Parent Item:

D350-748-101

D350-748-101

Parent Item Name: Crosstube Installation, High Fwd

Start Date: 21/12/2011

Required Date: 13/01/2012

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev:A New Issue 06-07-05 JLM

IPP Rev:B Update qty of MS21042L5 06-09-12 KJ

IPP Rev:C Rev B 07-11-15 DD

IPP Rev D Combined manufacturing 08.04.02 EC verified by: DD IPP Rev:E 08-06-24 revD as per dwg DD verified by:EC 10.08.04 added OSI010.4.3 DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D350-748-141TRN		Manufactured	No			110	Each	0.0000	1	1			
D350-748 Crosstube Turning Detail	R-141TF	N				/	B7458	77	**	SAC)	12-01	67
ALS4-1032-225		Purchased	No			200	Each	1,348.000	1	1			
ALS4-103	32-225								**				
Insert				Location		<u>La</u>	c Oty	Loc Code					
				ST281			1348						

insert											
				Location	<u> </u>	oc Qty	Loc Code				
				ST281		1348					
				108696		199				ξ	
				110768		62					
				118386		858					
				118966		229					
AN960JD10	NAS1149D0363J	Purchased	No		200	Each	0.0000	1	1		
AN960.ID	10							**			
D2856-400		Manufactured	No		200	f	200.2721	1.181	1.243158		
*D2856-40	0 *							**			

Abraison Strip

Location	Loc Oty	Loc Code	
ST409	200.2721		
63735	0.6696		
68076	0.3149		
71164	21.66		
73491	177.6276		

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W/O:			WC	ORK ORDER CHANG	ES				
DATE	STEP	PR(OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No		PAR #:	Fault Cate	gory:	_ NCR: Yes	No DQ	A:	Date:	
	Res	solution:	Disposition	n:	_ QA: N/C (closed:		Date: _	· · -
NCR:			WORK ORD	ER NON-CONFORMA	ANCE (NC	R)			
DATE	STEP Description of NC Section A		ion A Initial Action Des		cription Sign &			Approval Chief Eng	Approval QC Inspector
			Chief Eng	Chief Eng	Date				
		, , , , , , , , , , , , , , , , , , ,							

Picklist Print Page 2 December-21-11 9:29:02 AM Work Order ID: 77767 *77767* D350-748-101 Parent Item: *D350-748-101* Parent Item Name: Crosstube Installation, High Fwd Start Date: 21/12/2011 **Required Date:** 13/01/2012 Start Qty: 1.00 Required Qty: 1.00 D3502-1 Manufactured No 200 Each 23.0000 2 2 *D3502-1* ** Support Location Loc Qty Loc Code ST063 23 72129 3 73419 20 MS21920-20 Purchased 200 No Each 60.0000 *MS21920-20* ** Clamp (per MIL-DTL-8783C) Location Loc Qty Loc Code LG050 60 116799 10 119386 50 MS27039-1-10 Purchased No 200 Each 41.0000 **

MS27039-1-10

Screw

Location Loc Qty Loc Code ST291 41 119307 3 119531 38

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W/O:			W	ORK ORDER CHANGE	ES				
DATE	STEP	PRO	OCEDURE CHA	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No		PAR #:	Fault Cate	egory:	NCR: Yes	No DQ	A :	_ Date: _	
	Resolution:			on:	QA: N/C CI	osed:		Date: _	
NCR:		,	WORK ORD	ER NON-CONFORMA	NCE (NCF	R)			
DATE	STEP	Description of NC		Corrective Action Section		Verific	cation	Approval	Approval
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Picklist Print

Page 4

December-21-11 9:29:02 AM

Work Order ID: 77767		*7	7767*						
Parent Item: D350-748-101			350-748-	101*					
Parent Item Name: Crosstube Installation	on, High Fwd	1 /	. 1. 1()- / 4()-	1 (/ 1		St	art Date: 2	1/12/2011	Required Date: 13/01/2012
						S	tart Qty: 1	.00	Required Qty: 1.00
AN960JD516 NAS1149D05633	Purchased	No		220	Each	0.0000	8	8	
AN960.ID516							**		
D3500-1	Manufactured	No		220	Each	4.0000	4	4	
D3500-1							**		
			Location	Lo	c Qty	Loc Code			
			ST424		4				wood
			70695		4				<u> </u>
D3501-1	Manufactured	No		220	Each	396.0000	16	16	
D3501-1 Bushing							**		
			Location	<u>Lo</u>	c Qty	Loc Code			
			ST063		396				_
			67757		4				_
			70682 73391		100 85				_
			74866		207				_
MS21042L4	Purchased	No		220	Each	9,077.000	24	24	_
MS21042I 4							**		
			Location	Lo	c Oty	Loc Code			
			ST300		9077				_
			117441		51				
			117601		342				_
			118451 119017		133 3551			-	_
			119077		5000				

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Part No	:	PAR #:	Fault Cate	gory:	NCR: Yes	No DQ	A:	Date: _	
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NCR:			WORK ORD	ER NON-CONFORMA	NCE (NC	R)			
DATE	STEP	Description of NC		on B	Verifi	cation	Approval	Approval	
DAIL	SILF	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date		tion C	Chief Eng	QC Inspector
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Picklist Print

December-21-11 9:29:02 AM

Work Order ID: 77767

Parent Item:

D350-748-101

Parent Item Name: Crosstube Installation, High Fwd

77767

D350-748-101

Start Date: 21/12/2011

Required Date: 13/01/2012

Page 5

Start Qty: 1.00

Required Qty: 1.00

MS21042L5

Purchased

No

220

Each

2,130.000

**

MS21042L5

<u>Location</u>	Loc Qty	Loc Code	
ST300	2130		
116105	5		
116548	43		
117611	52		
118179	496		
118910	34		
119109	1500		

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W/O:			\ \	VORK ORD	ER CHAN	IGES	•				•
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Resolution:				Fault Category: NCR: Yes No DQA: Date: Disposition: QA: N/C Closed: Date:						4	
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DART AEROSPACE LTD	Work Order:	77767
Description: Crosstube High Fwd (AS350/355)	Part Number:	D350-748-101
Inspection Dwg: D350-748-141 Rev: F		Page 1 of 1

	Required Dimension	Min	Max	
	Height	23.13	23.37	
	1/2 Span	40.78	41.02	
	Angle	75	77	
	Total Span	81.56	82.04	
	194-4.448		199 - 4.437)
	4.370		4.4 %	
T				A
	2.321		7.316	
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	-0.72	0 1		
	1	81.530		

Comments								
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Sine	A- Z	4.3 %	crushing.	Q 44 Passes				
Sine	BZ	4.470	crushing	W 39 PASA				

QC15 Inspection	
Date	

Rev	Date	Change	Revised by Approve
Α	07.02.06	New Issue	KJ/JM
В	10.08.23	Dwg Rev updated	KJ 1\ \frac{1}{2} \
С	11.11.07	Dwg Rev updated	KJ OK M

Dart Aerospace	Ltd
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W/O:			W	ORK ORDER CHANG	GES					
DATE	STEP	PRO	OCEDURE CH	ANGE	_	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	<u> </u>	PAR #:	Fault Cate	egory:	NCR	: Yes I	No DQ	A:	Date:	
Resolution:			Disposition: QA			QA: N/C Closed: Date				
NCR:			WORK ORD	ER NON-CONFORM	IANCE	(NCR)				
DATE	STEP	Description of NC Section A	Corrective Action S Initial Action Descriptio		ection B Sign 8		Verification Section C		Approval Chief Eng	Approval QC Inspector
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В

ltem	Qty -141	Part Number	Description
1	Х	D350-748-141	CROSSTUBE ASSEMBLY (AS 350/355 HI FWD)
2	1	D6015-125	CROSSTUBE (OR D6017-115)
3	2	D3502-1	SUPPORT
4	2	D2856-400-710	ABRASION STRIP
5	1	AELS-1032-225	INSERT
6	1	NAS1149D0363J	WASHER (OR AN960JD10)
7	2	MS21920-20	CLAMP (PER DART SPEC. M-MS21920-20)
8	1	MS27039-1-10	SCREW

UNCO **SUBJ!** NO. 77767 M.C.J

GENERAL NOTES:

1) MATERIAL: MANUFACTURED FROM D6015-125 OR D6017-115

FINISHED LENGTH = 110.270±0.06

2) FINISH: MAGNETIC PARTICLE INSPECT PER DART QSI 038 4.2 CADMIUM PLATE PER AMS-QQ-P-416B, CLASS 1, TYPE II PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2 PAINT OUTSIDE PER DART QSI 005 4.2

- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- UNITS: INCHES UNLESS OTHERWISE NOTED.

BREAK SHARP EDGES: 0.005 TO 0.010 MAX.

- IDENTIFICATION: DART PART NUMBER "D350-748-141" AND BATCH NUMBER ON INSIDE OF CUFF PER DART QSI 044 6.4 (VIBRATING STYLUS)
- WEIGHT: 30.45 lbs

PART IS SYMMETRIC ABOUT CENTERLINE, EXCEPT FOR Ø0.297 HOLE.

- BLEND OUT ALL EDGES FROM MACHINING LONGITUDINALY, TRANSITION SHOULD BE SMOOTH. NOTE: ALL HOLES ARE DRILLED AFTER BENDING.
- 10) BEND PROGRESSIVELY WITH A MINIMUM OF 7 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.

11) HEAT TREAT TO MIN. 180 KSI PER MIL-T-6736 OR AMS 2759-1C AFTER TURNING. ACCEPTABLE TO VERIFY TENSILE STRENGTH BY HARDNESS TEST PER ASTM E18 TO 40-45 HRC.

12) INSTALL D2856-400-710 ABRASION STRIPS WITH A GAP ON BOTTOM SIDE OF CROSSTUBE. CENTERED OPPOSITE D3502-1 SUPPORT, PER QSI 035.

13) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005° MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE. WHEN DRILLING HOLES EXTREME CARE MUST BE TAKEN AND CAREFUL DEBURRING PERFORMED TO ENSURE A CLEAN HOLE WITH NO CRACKING/CHIPPING/GROOVES.

14) TORQUE CLAMPS 60 TO 80 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

15) MAX TWIST AFTER BENDING: WITH XTUBE LAYED FLAT ON SURFACE, THE DIFFERENCE BETWEEN CUFF HEIGHTS FROM THE SURFACE MAY BE NO LARGER THAN 0.25 (ZN C1-3).

UNDER REVIEW \$ 11.07.12

В

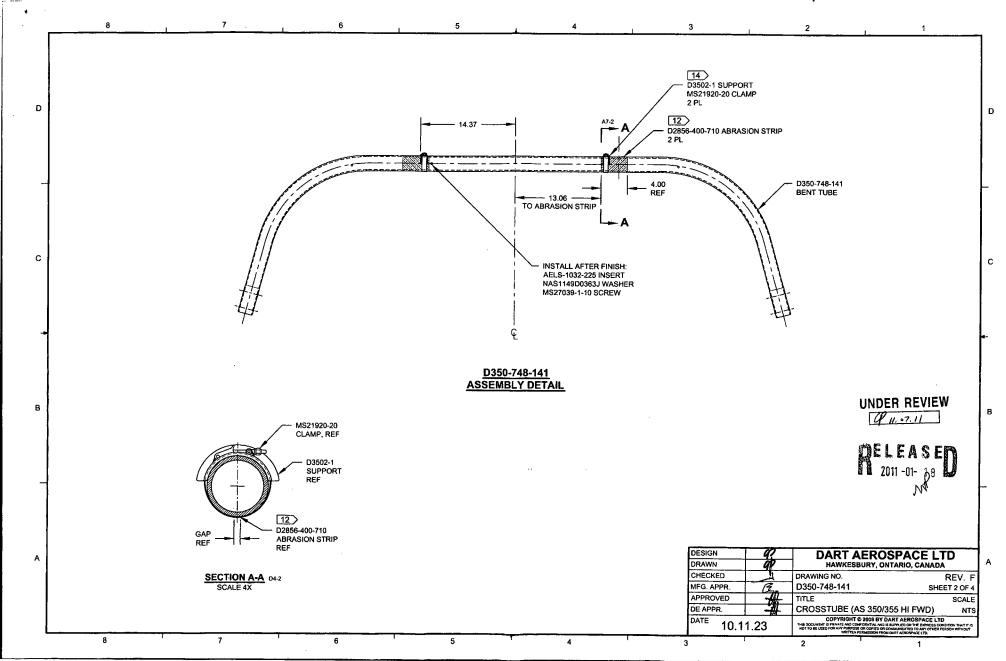
F	TWIST	RC TEST OPT LIMIT (A8-1, C , STOCK DIM	СР	10.11.23		
E	STANE	E GENERAL N DARDS; RELO -3); TOLERAN	RF	09.09.30		
D	MAG. F	PARTICLE AND	CAD PLATE AS MFD.	CP	06.10.31	
С	ADD C	AD PLATING	CP	06.08.14		
В	ADD D	6017-115 & PF	CP	06.06.30		
Α	NEW IS	SSUE	CP	06.03.31		
REV.			BY	DATE		
DESIGN		q?	DART AEROSPA	ACE	LTD	
DRAWN	_	97	HAWKESBURY, ONTARI			
CHECKE	D	A	DRAWING NO.		REV. F	
MFG. AF	PR.	E.	D350-748-141 SHEET 1			
APPRO\	/ED	1/4	TITLE		SCALE	
DE APP	۲.	#	CROSSTUBE (AS 350/355 H	II FWD) NTS	
DATE 10.11.23			COPYRIGHT © 2006 BY DART AS THIS DOCUMENT IS PRIVATE AND COMPOSITION, AND IS SUPPLIED. NOTTO BE USED FOR ANY PURPOSE OR COMED OR COMMUNICATION WINTED IN POLICISION FROM DART ASS	ON THE EXPRES	00.00mmm/s.17.47.47.4	

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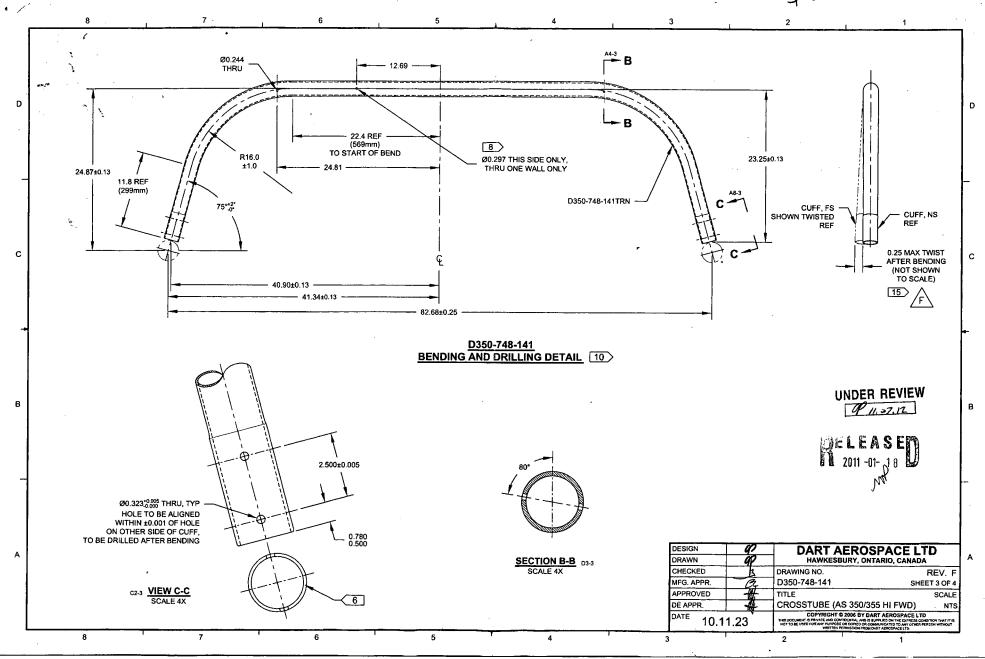
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DATE	STEP	Description of NC						Approval	Approval
DAIL	SIEF	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Secti	on C	Chief Eng	QC Inspector

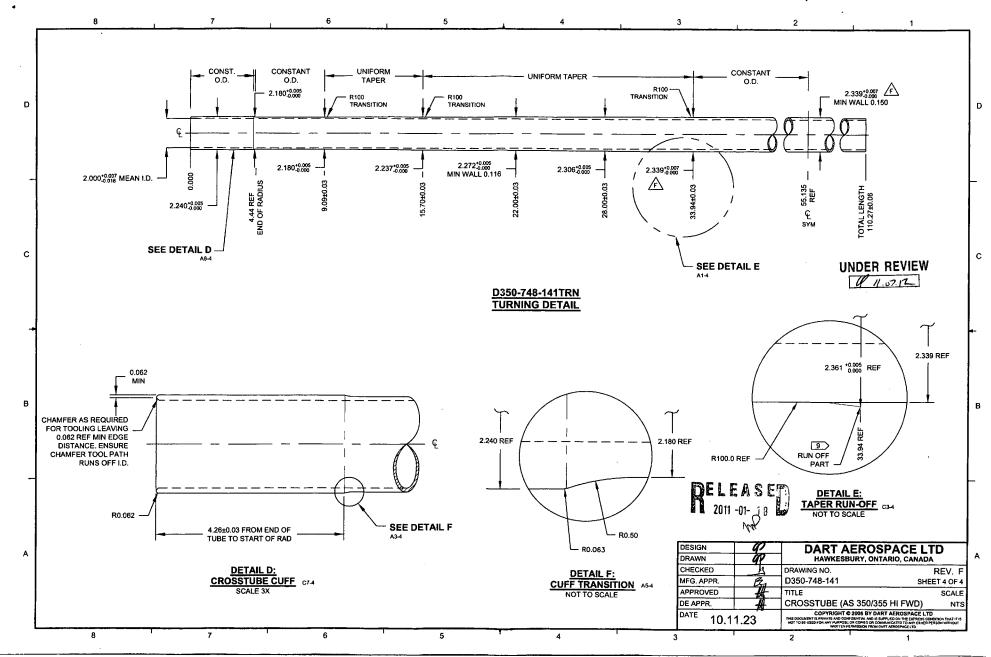


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J7767



W/O:		WORK ORDER CHANGES									
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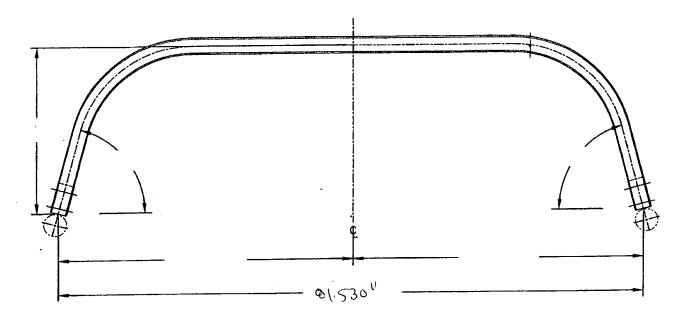
Dart Aerospa	ce	Ltd
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DATE STEP		Description of NC Corrective Action Section E			Verification		Approval Approval		
DATE 3	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng (QC Inspector		
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DART AEROSPACE LTD	Work Order:	77767
Description: Crosstube High Fwd (AS350/355)	Part Number:	D350-748-101
Inspection Dwg: D350-748-141 Rev: F		Page 1 of 1

For stress letter

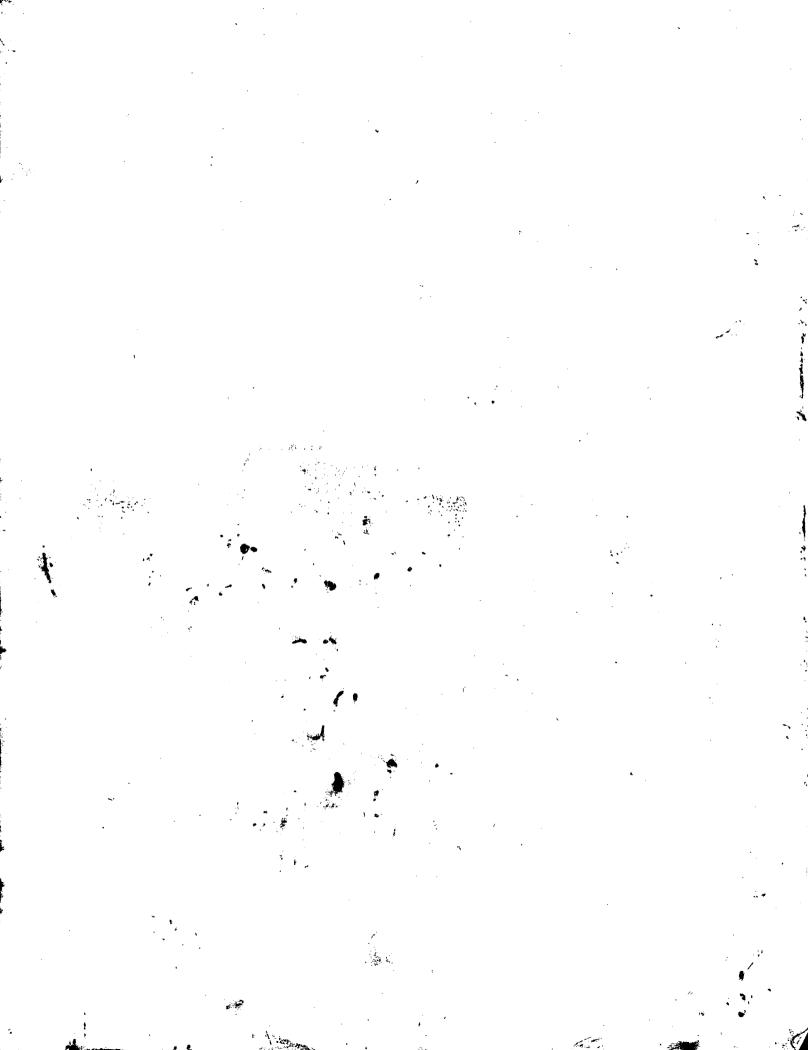
Required Dimension	Min	Max
Height	23.13	23.37
1/2 Span	40.78	41.02
Angle	75	77
Total Span	81.56	82.04



Comments	
twist = 0.404	

QC15 Inspection	
Date	

Rev	Date	Change	Revised by	Approved
Α	07.02.06	New Issue	KJ/JM	
В	10.08.23	Dwg Rev updated	KJ 1()	14
С	11.11.07	Dwg Rev updated	KJ OK	_ <i>A</i> 0



CADORATH GROUP NON CONFORMANCE REPORT

CADORATH AEROSPACE CADOR	ATH DISTRIBUTION			
CADORATH COATING	UNIFLYTE			
NOTE: THIS FORM MUST BE COMPLETED BY: CUSTOMER VENDOR	BEFORE PROCESSING OF PART(S)			
	NCR#: <u>C1115</u>			
CUSTOMER: Dart Aerospace Ltd.	date: <u>02/24/12</u>			
VENDOR: \(\sum_{N/A} \)	CADORATH/UNIFLYTE P/O #:			
PART DESCRIPTION: Skid (Crosstube)	N/A ے			
CUSTOMER P/O #: PO 15990	CADORATH/UNIFLYTE W/O #:			
PART #: D350-748-101	111679/80/81/82/86			
SERIAL #: 77767, 77768, 77769, 77770 and 76254	QUANTITY: Five (5)			
PURCHASE ORDER INSTRUCTIONS: MPI and Cad Plate				
DISCREPANCY: These parts failed our MPI test after plating. The were shipped back to your facility as of February 24, 2012.	ey all have cracks. The parts			
Nick Wasylik (QA Manager) CADORATH/UNIFLYTY INSPECTION DEPART	W. CI 02/29/12 MENT 14 02/29/12			
CUSTOMER: PLEASE COMPLETE THIS PORTION, SIGN AND RETURN TOP COPY OF THE PROPERTY OF THE PROPE	OF THIS FORM TO CADORATH/UMFLYTE			
DATE: 02/24/12 P/O: PO 15990				
CUSTOMER INSTRUCTIONS: ATTENTION: Chantal Lavoie VENDOR CORRECTIVE ACTION: Since the 5 parts were returned, this NCR is the notification that they were sent back for				
your evaluation.	The state of the s			
·	<u> </u>			
	esylik (QA Manager)			
	TATATA MAN TITLE			

DATE: 10/13/10

FORM: OPS 097 REVISION: 3

